



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D3913-041
Job Sheet 199700



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/29/19

Job Tracking No:

Due Date: 9/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	9/30/19		0.00	19.61	Large Fab - 1		CC
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	9/30/19		0.00	0.00	QC 9 - 10		DAS 24 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	9/30/19		0.00	0.00	QC 5 - 10		DAS 24 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



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Container No: S220780



Part: D3913-041

Job No: 199700

Serial No/Batch: S220780

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/08/19

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						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
125 Handfinish - 2-1 Pressure-B4B	1 pcs	9/30/19	0.00	0.29	Handfinish - 2 - 1 - B4B	BEB 19-10-10	
					Handfinish - 2 - 2 - B4B		
					Handfinish - 2 - 3 - B4B		
					Handfinish - 2 - 4 - B4B		
130 Powdercoat - 2 White Gl(S)-B4B	1 pcs	9/30/19	0.00	0.93	Powdercoat - 1 - B4B		
					Powdercoat - 2 - B4B		
					Powdercoat - 3 - B4B	BR 19-10-11	
					Powdercoat - 4 - B4B		
140 QC 3	1 pcs	9/30/19	0.00	0.00	QC 3 - 10		
					QC 3 - 13		
					QC 3 - 15		
					QC 3 - 17		
					QC 3 - 18		
					QC 3 - 2		
					QC 3 - 28		
					QC 3 - 3		
					QC 3 - 30		
					QC 3 - 34		
					QC 3 - 36		
					QC 3 - 41		
					QC 3 - 51		
					QC 3 - 58		
					QC 3 - 59	BEB 19-10-11	
					QC 3 - 68		
					QC 3 - 9		
					QC 3 - 40		
					QC 3 - 19		
					QC 3 - 43		
					QC 3 - 24		
					QC 3 - 61		
					QC 3 - 81		
150 Handfinish - 4-1-Assembly-B4B	1 pcs	9/30/19	0.00	0.50	Handfinish - 4 - 1 - B4B		
					Handfinish - 4 - 10 - B4B	BEB 19-10-11	
					Handfinish - 4 - 11 - B4B		
					Handfinish - 4 - 12 - B4B		
					Handfinish - 4 - 13 - B4B		
					Handfinish - 4 - 14 - B4B		
					Handfinish - 4 - 15 - B4B		
					Handfinish - 4 - 2 - B4B		
					Handfinish - 4 - 3 - B4B		
					Handfinish - 4 - 4 - B4B		

160 QC 5	1 pcs	9/30/19	0.00 0.00	Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
170 Packaging 3-1 - Stock - B4B	1 pcs	9/30/19	0.00 0.00	QC 5 - 40	OCT 11 2019
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	BER 19-10-11
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	

					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	9/30/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - Weld per dwg A/R S.S. rod Batch: _____ 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect
 Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to
 fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket 4- Weld D4672-1 blanking plates as per dwg
 110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder
 coat
 140 - QC3- Inspect Part Finish
 150 - Assemble as per dwg - Pick Kit
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S211240
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S215071
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	S184576
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S209250
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S214637
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S210802
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	S214362
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	S217493
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	S213354
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	S212014
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S214665
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S212873
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	S216384
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	S216390
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	S216456
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	S210714
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	S206463
AN3-10A	BOLT	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	S212401-1
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S196541
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	S204283-1
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	S207709
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S208582
NAS1149FN832P	Washer (AN960-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S136368

~~Not allocated~~

M.U. 012386

Master Unit: 012215

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	41	0
	D3913-1	1	11	0
	D3913-15	1	17	0
	D3913-3	1	15	0
	D3913-7	2	12	0
	D3913-9	1	6	0
	D3916-041	2	2	0
	D3916-5	3	19	0
	D4016-1	3	19	0
	D4017-7	3	31	0
	D4017-9	2	8	0
	D4020-11	2	8	0
	D4021-1	3	19	0
	D4034-041	1	4	0
	D4034-043	1	5	0
	D4672-1	2	1	0
	M304EX0.75-16F	32	1,051	0
150-Handfinish - 4-1-Assembly-B4B	AN3-10A	6	180	0
	D2931	2	677	0
	D4021-5	2	24	0
	MS20600-AD4W3	2	448	0
	MS21042L3	6	1,476	0
	NAS1149F0332P	12	2,802	0
	NAS1149FN832P	2	2,457	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐
					Quality ☐
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042) _____	
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				
Completed By _____		Lead hand / Supervisor _____			
QC / QA Coordinator _____					